

24

Date: Wednesday, 5/16/2007 8:03:25 AM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|---------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FLOAT SKID LH 206L1,L3,L4&407 |
| Job Number | : 32360 | | |
| Estimate Number | : 10307 | | |
| P.O. Number | : N/A | Part Number | : D206642511 |
| This Issue | : 5/16/2007 S.O. No. : N/A | Drawing Number | : D206-642 PG22-23 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : LANDING GEAR | Drawing Revision | : K |
| Previous Run | : 32359 | Material | : N/A |
| Written By | : <u>9/10/05.16</u> | Due Date | : 6/10/2007 Qty: 1 Um: Each |
| Checked & Approved By | : <u>9/10/05.16</u> | | |
| Comment | : Est Rev:B 05-09-23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-511CHG003

07-05-30

| | | |
|-----|--------|-------------------------|
| 2.0 | 32360A | FLOAT SKIDTUBE ASSEMBLY |
|-----|--------|-------------------------|



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

D206-642-541 B B 32360 A

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

D206-511 B 33229 Per 1/12

| | | |
|-----|------------|---------|
| 4.0 | D206648013 | GHW Kit |
|-----|------------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|

| | | | |
|---|--------------|---------|--|
| 1 | D206-648-013 | GHW Kit | |
|---|--------------|---------|--|

| | | | |
|---|-------------------|--|--|
| 1 | D206-642-541(REF) | | |
|---|-------------------|--|--|

N/A

| | | |
|-----|-------|---------|
| 5.0 | D2652 | Bushing |
|-----|-------|---------|



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|

| | | | |
|----|-------|---------|--|
| 16 | D2652 | Bushing | |
|----|-------|---------|--|

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:03:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 32360

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

7.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

8.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

9.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

10.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

11.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

NA

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:03:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 32360

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

13.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

14.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

15.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

16.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

17.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:03:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 32360

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

19.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

20.0

AN4C6A



Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

21.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

22.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

23.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:03:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 32360

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

25.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

26.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

27.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

28.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

29.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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Date: Wednesday, 5/16/2007 8:03:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 32360

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 8 | AN960C516L | Washer | |

31.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 20 | MS21043-3 | Nut | |

32.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 13 | MS21043-4 | Nut | |

Handwritten signature/initials

33.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|-------|
| 4 | MS21043-5Nut | | |

34.0

NAS1515H3L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 24 | NAS1515H3L | Washer | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:03:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 32360

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer

36.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H5

Washer

37.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H5L

Washer

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-511

Location:

Rec C

7/2/11

sq

CR

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



B32-360A

10/07/13
11-07-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

4.5 206L/L-1/L-3/L-4/407 High Gear Float Skidtubes (TRI-BAG COMPATIBLE)

| Item | Qty -511 | Qty -512 | Qty -541 | Qty -547 | Qty -013 | Part Number | Description |
|------|-------------|-------------|-------------|-------------|-------------|---|---|
| | X | | | | | D206-642-511 | SKIDTUBE INSTALLATION, LH |
| | | X | | | | D206-642-512 | SKIDTUBE INSTALLATION, RH |
| | 1 | 1 | X | | | D206-642-541 | SKIDTUBE |
| | | | | X | | D206-642-547 | WEARSHOE KIT (REPLACES -543 KIT) |
| | 1 | 1 | | | X | D206-648-013 | GROUND HANDLING KIT |
| 1 | | | 1 | | | D3274-041 | SKIDTUBE ASSEMBLY |
| 3 | | | 1 | | | D2646 | * AFT CAP ⁽¹⁾ |
| 4 | | | 2 | | | AN3C4A | * BOLT ⁽¹⁾ |
| 5A | | | 2 | | | AN960C10L | * WASHER ⁽¹⁾ |
| 5B | | | 2 | | | NAS1515H3L | * WASHER ⁽¹⁾ |
| 6 | 1 | | | | | D2932-1 | SADDLE, FWD OUT, LH |
| 6 | | 1 | | | | D2932-2 | SADDLE, FWD OUT, RH |
| 7 | 1 | | | | | D2933-1 | SADDLE, FWD IN, LH |
| 7 | | 1 | | | | D2933-2 | SADDLE, FWD IN, RH |
| 8 | 1 | | | | | D2938-1 | SADDLE, AFT OUT, LH |
| 8 | | 1 | | | | D2938-2 | SADDLE, AFT OUT, RH |
| 9 | 1 | | | | | D2939-1 | SADDLE, AFT IN, LH |
| 9 | | 1 | | | | D2939-2 | SADDLE, AFT IN, RH |
| 10 | 8 | 8 | | | | AN3C41A | BOLT |
| 11 | 16 | 16 | | | | D2652 | BUSHING |
| 12A | 8 | 8 | | | | MS21043-3 | NUT |
| 12B | 16 | 16 | | | | NAS1515H5 | WASHER |
| 13 | 4 | 4 | | | | AN5C11A (or AN5C12A) | * BOLT ⁽²⁾ |
| 14 | 4 | 4 | | | | AN5C11A (or AN5C13A) | * BOLT ⁽²⁾ |
| 15A | 8 | 8 | | | | AN960C516L | WASHER |
| 15B | 8 | 8 | | | | NAS1515H5L | WASHER |
| 16 | 12 | 12 | | | | AN4C6A | BOLT |
| 17A | 24 | 24 | | | | NAS1515H4L | WASHER |
| 17B | 24 | 24 | | | | AN960C416L | WASHER |
| 18 | 12 | 12 | | | | MS21043-4 | NUT |
| 20A | | | 9 | 9 | | D3537-1 | * WEARPAD ⁽¹⁾ (REPLACES D2648-3) |
| 21A | | | 1 | 1 | | D3537-3 | * WEARPAD ⁽¹⁾ (REPLACES D3429-1) |
| 22A | | | 1 | 1 | | D3535-15 | * WEARSHOE ⁽¹⁾ (REPLACES D2656-15) |
| 22B | | | 1 | 1 | | D3536-15 | * GASKET ⁽¹⁾ |
| 23A | | | 1 | 1 | | D3535-23 | * WEARSHOE ⁽¹⁾ (REPLACES D2656-23) |
| 23B | | | 1 | 1 | | D3536-23 | * GASKET ⁽¹⁾ |
| 24A | | | 1 | 1 | | D3535-39 | * WEARSHOE ⁽¹⁾ (REPLACES D3287-1) |
| 24B | | | 1 | 1 | | D3536-39 | * GASKET ⁽¹⁾ |
| 25A | | | 1 | 1 | | D3535-35 | * WEARSHOE ⁽¹⁾ (REPLACES D2656-35) |
| 25B | | | 1 | 1 | | D3536-35 | * GASKET ⁽¹⁾ |
| 26A | | | 78 | 78 | | AN3C4A | * BOLT ⁽¹⁾ |
| 26B | | | 78 | 78 | | AN960C10L | * WASHER ⁽¹⁾ |
| 26C | | | 78 | | | ALS7-1032-130 (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) | * INSERT ⁽¹⁾ |
| 30 | 1 | 1 | | | | D3407-043 | TOW RING |
| 32A | 1 | 1 | | | | D3456-1 | WASHER |
| 32B | 2 | 2 | | | | D3457-1 | WASHER |
| 33 | 1 | 1 | | | | MS21043-4 | NUT |
| 34 | | | 1 | | | AN4C5A | BOLT |
| 35 | | | 1 | | | AN960C416 | WASHER |
| 36 | | | 1 | | | D3413-1 | RING |
| 37 | 10 | 10 | | | | D2712 | SET SCREW |
| 38 | 2 | 2 | | | | D2934 | SADDLE SPACER |
| 39 | 2 | 2 | | | | D2935 | SADDLE SPACER |

continued on next page...

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32360

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Revision: **K**
Date: 06.09.25

continued from previous page...

| ITEM | QTY -511 | QTY -512 | QTY -541 | QTY -547 | QTY -013 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-------------|-------------|--------------------|
| | | | | | | | |
| 40 | | | | | 2 | D3414-041 | LUG ASSEMBLY (GHW) |
| 41 | | | | | 4 | AN3C37A | BOLT |
| 42 | | | | | 8 | D2652 | BUSHING |
| 43 | | | | | 4 | MS21043-3 | NUT |
| 44 | | | | | 4 | AN960C10 | WASHER |
| | | | | | | | |
| 50 | 9 | 9 | | | | AN3C36A | BOLT |
| 51 | 3 | 3 | | | | AN3C35A | BOLT |
| 52 | 24 | 24 | | | | AN960C10L | WASHER |
| 53 | 24 | 24 | | | | NAS1515H3L | WASHER |
| 54 | 12 | 12 | | | | MS21043-3 | NUT |
| 55 | 2 | 2 | | | | D3396-3 | SPACER |
| 56A | 1 | 1 | | | | AN5C35A | BOLT |
| 56B | 1 | 1 | | | | AN5C15A | BOLT |
| | | | | | | | |
| 60 | 2 | 2 | | | | AN5C32A | BOLT |
| 61 | 2 | 2 | | | | AN5C34A | BOLT |
| 62 | 4 | 4 | | | | MS21043-5 | NUT |

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32360

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Revision: **K**
Date: 06.09.25

24

Date: Wednesday, 5/16/2007 8:04:20 AM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|-----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FLOAT SKIDTUBE ASSEMBLY |
| Job Number | : 32360A | | |
| Estimate Number | : 10309 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D206642541 |
| This Issue | : 5/16/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3274 REV D |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : LANDING GEAR | Drawing Revision | : D |
| Previous Run | : 32359A | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 6/10/2007 Qty: 1 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> | | |
| Comment | : Est Rev:B 05-09-23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-541 CHG003 *N/A*

| | | |
|-----|-----------|------------------------|
| 2.0 | D26001190 | Extrusion Round 3" 206 |
|-----|-----------|------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|

| | | | |
|---|-------------|------------|---------------|
| 1 | D2600-1-190 | 3" OD Tube | <i>B24841</i> |
|---|-------------|------------|---------------|

DP 7-5-18

| | | |
|-----|----------------|-------------------------|
| 3.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 7-5-18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:04:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 32360A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

JB 7-5-18

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pm 07-06-07 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE / Pm 07-06-07 (1)

7.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B32405

EL 7-6-6

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

4-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

Sikaflex expire date:

Start: 7-6-7

Finish: 07-06-11

(Adhere for 12 hours)

M 123561

7-10-1

Time: 11:15

Time: 8:00

R 7-6-7

DP
7-6-7

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE / Pm 07-06-11 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:04:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 32360A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

5-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

6- Countersink crossbolt spacer holes as per Dwg D3274

EL 7-6-11

Pm 07-06-280

Pm 07-06-280

Pm 07-06-280

Pm 07-06-280

11.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|------------|
| 1 | D3285-1 | Fwd Cap | BE 0707-03 |

12.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|------------------|-------------|
| 12 | D2649 | Crossbolt spacer | BE 07-07-03 |

13.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|------------------|------------|
| 12 | D3275-1 | Crossbolt spacer | BE 0707-03 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:04:21 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 32360A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod M 104221 / M 104305 BE 07-07-03

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod M 104221 BE 07-07-03

3-Grind welds flush to Fwd cap on top surface only. BE 07-07-03

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube FW 07-07-03

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr. FW 07-07-03

15.0

QC59

WELD INSPECTION



Qc9 M 07/07/04
Qc15 En 07/07/04 (41)



Comment: Inspect weld and Counterbore. Inspect for foreign objects as per QSI 024

16.0

POWDER COATING

POWDER COATING



M 101575



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/FJ. 07-07-06

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



FW 07-06 (41)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3415-041 Nut Plate D30837

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

FW 07/07/06 (41)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:04:21 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 32360A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 CCR264SS3-3 Rivet m/14651

20.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CR3212-4-03 Rivet m/15918

21.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Insert

Batch: m/103618

FL 07/07/06 ①

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 m/104161

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R Sikaflex-291 m/104732

Sikaflex expire date: 05/10

FL 07/07/06 ①

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Nut Plate & Inserts

En 07/07/09 ①

24.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)

BOLT

Batch: m/104537

FL 07/07/09 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 32360A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B31990

26.0

D353523

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B32411

27.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B31992

28.0

D353539

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B32412

29.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B30753

30.0

D353623

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32413

31.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B30755

FL 07/07/09 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 32360A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D353639

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32414

33.0

D35371

WEARPAD



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

WEARPAD

Batch: B32539 ~~B32539~~ (x2) B32287.

45 07-07-12 (1)

34.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B32789

35.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer

m104885

36.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 NAS1515H3L

Washer

m104603

37.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3413-1

Ring

B32408

38.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

FL 07/07/09 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 32360A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 AN4C5A

Bolt

m/18918

39.0

AN960C416L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960C416L

Washer

m/100993

40.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B31335

FL 07/07/09 0

41.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291

m/104732

Sikaflex expire date:

07/10

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3

Batch:

m/104762

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

m/104732

Sikaflex expire date:

07/10

41 09-07-12 0
FL 07/07/09 0

42.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 07/07/09 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 01/07/13

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 32360A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

PPP 32360

6/7/12 (1)

44.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

10/10/13

Job Completion



U 07-07-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN CP | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3274 | REV. D SHEET 1 OF 4 |
| DATE 06.12.19 | | TITLE SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 04.03.15 | NEW ISSUE | |
| B | 04.08.09 | MOVE SADDLE HOLE: 42.14 WAS 42.76 | |
| C | 05.03.16 | ADD -043; NEW INSERTS | |
| D | 06.12.19 | NEW INSERTS, SS WEARSHOE + GASKET | |

RELEASED

07.02.12 [Signature]

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|---------------|---|
| X | | D3274-041 | SKIDTUBE ASSEMBLY |
| | X | D3274-043 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2600-1-240 | EXTRUSION |
| 1 | 1 | D2646 | AFT CAP |
| 12 | 12 | D2649 | CROSS BOLT SPACER |
| 12 | 37 | D3275-1 | CROSS BOLT SPACER |
| 1 | 1 | D3282-041 | FLOAT WEB |
| 1 | 1 | D3285-1 | CAP |
| 1 | 1 | D3413-1 | RING |
| 1 | 1 | D3415-041 | NUT PLATE |
| 1 | 1 | D3535-15 | WEARSHOE |
| 1 | 1 | D3535-23 | WEARSHOE |
| 1 | 1 | D3535-35 | WEARSHOE |
| 1 | 1 | D3535-39 | WEARSHOE |
| 1 | 1 | D3536-15 | GASKET |
| 1 | 1 | D3536-23 | GASKET |
| 1 | 1 | D3536-35 | GASKET |
| 1 | 1 | D3536-39 | GASKET |
| 9 | 9 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-3 | WEARPAD |
| 78 | 78 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80 | 80 | AN3C4A | BOLT |
| 1 | 1 | AN4C5A | BOLT |
| 1 | 1 | AN960C416 | WASHER |
| 80 | 80 | AN960C10L | WASHER |
| 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | NAS1515H3L | WASHER |

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291. ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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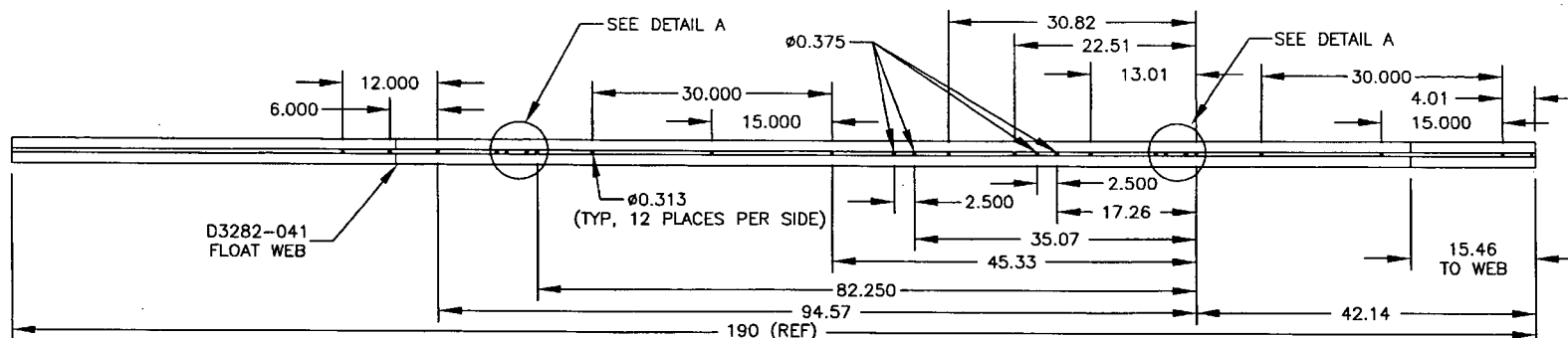
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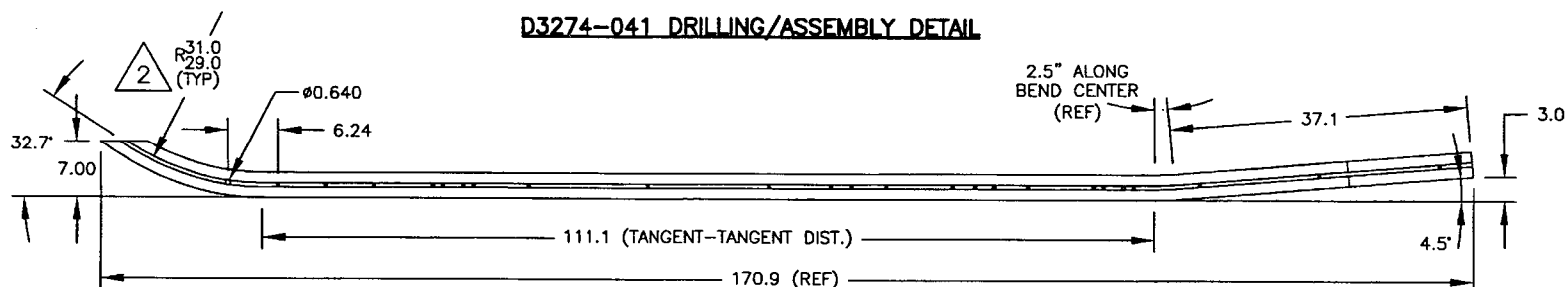
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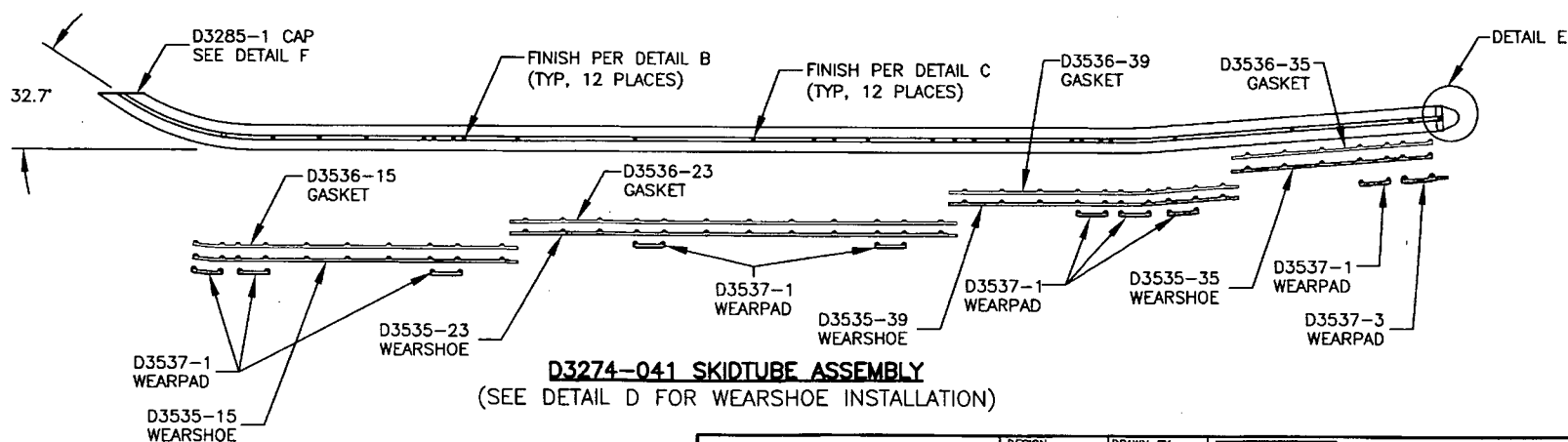
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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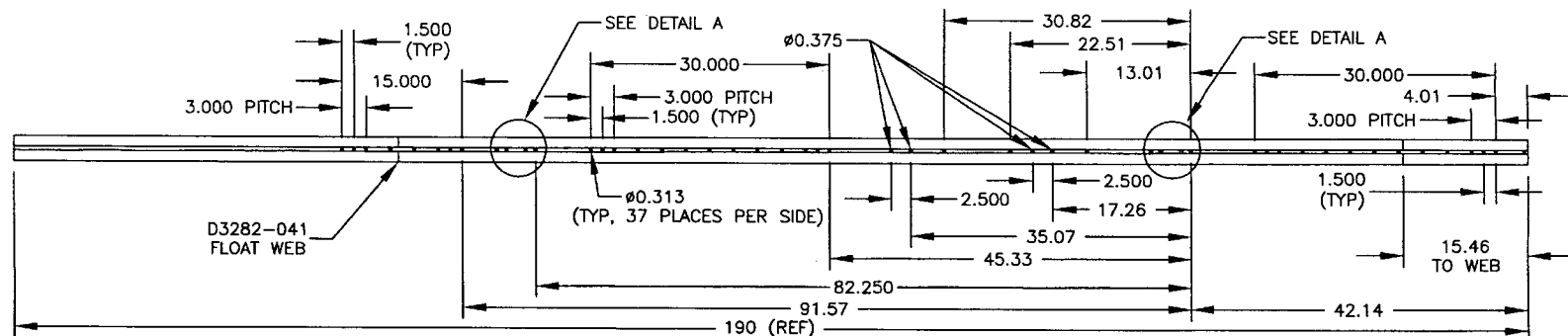
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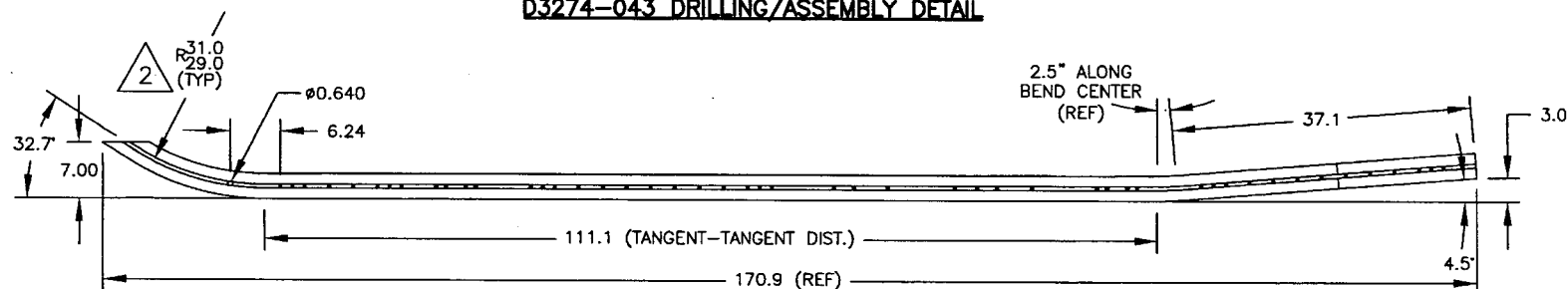
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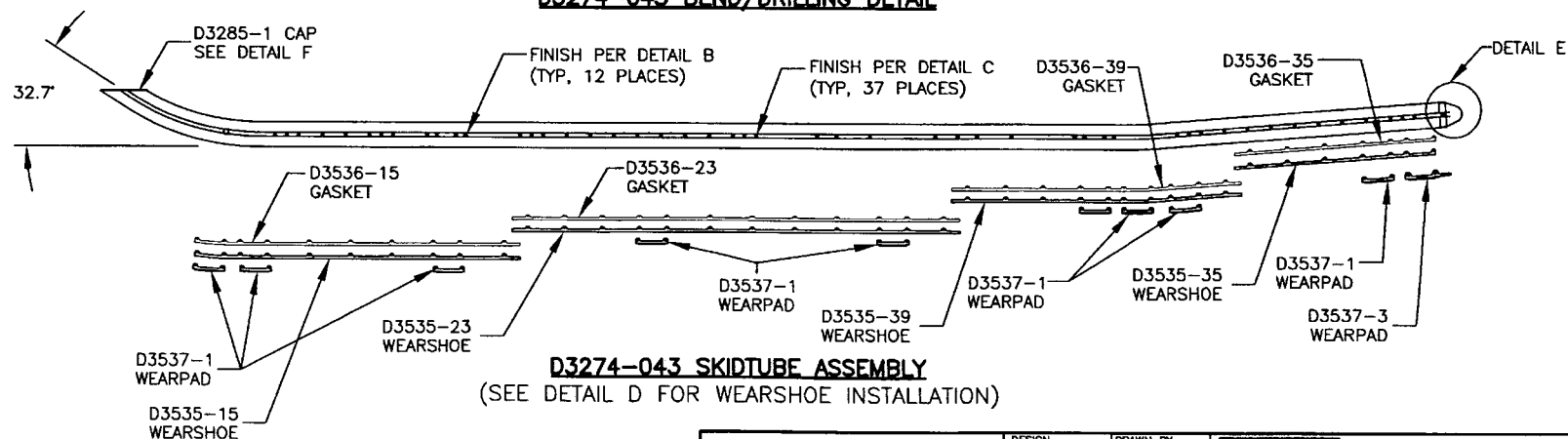
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| DESIGN | CP | DRAWN BY | PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, MA | REV. 0 |
| CHECKED | # | APPROVED | # | DRAWING NO. D3274 | SHEET 2 OF 4 |
| DATE | 06.12.19 | TITLE | SKIDTUBE ASSEMBLY | SCALE | 1:15 |



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

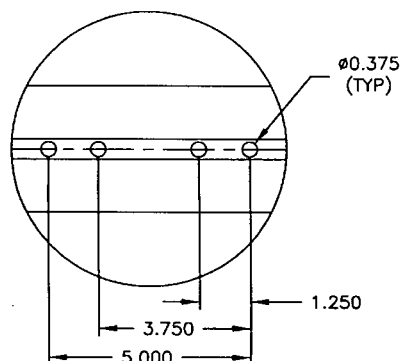
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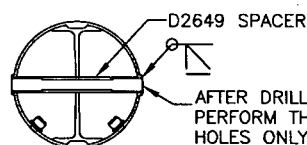
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| DATE | | 06.12.19 | D3274 | SCALE | |
| | | | TITLE | 1:15 | |
| | | | SKIDTUBE ASSEMBLY | | |

DETAIL A: DRILL DETAIL

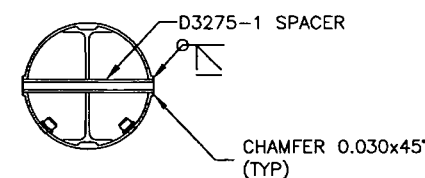


DETAIL B FOR 0.375 HOLES ONLY

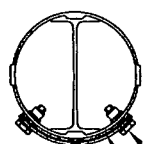


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY

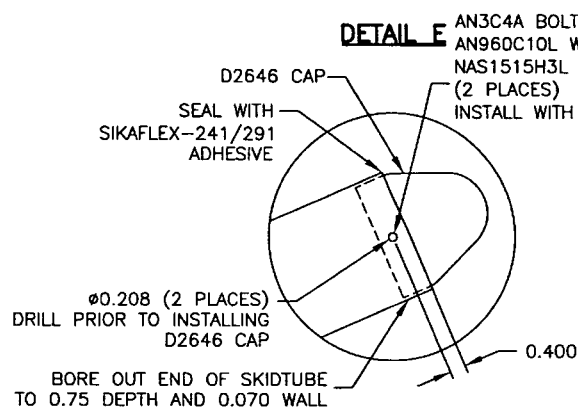


DETAIL D

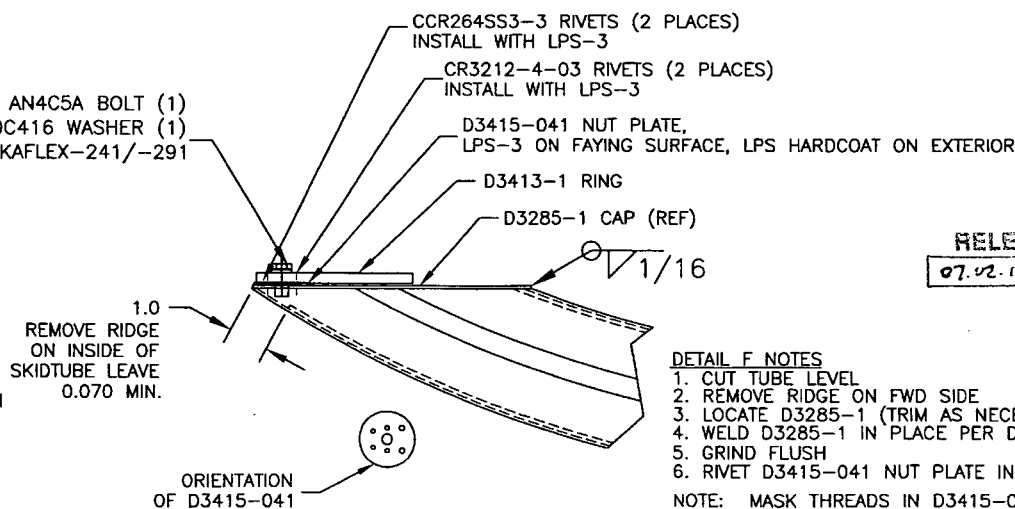


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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| | | D3274 | SHEET 4 OF 4 | |
| DATE | TITLE | SCALE | | |
| 06.12.19 | SKIDTUBE ASSEMBLY | | | 1:3 |

NO. 114

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliot
Joint Welding Procedure Tig
Part number and Job number D206 642 541 / B3297

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

| | Position | Vertical | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/> | 4G <input type="checkbox"/> |
| Tube Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/> | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/> | 4F <input type="checkbox"/> |
| Tube Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/> | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 01-06-20 Qualifier Pat Duval